

Date: Wednesday, 26/11/2008 12:46:51 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 43774		
Estimate Number	: 12953		
P.O. Number	:	Part Number	: D32595
This Issue	: 26/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3259 REV A1
First Issue	: / /	Project Number	: N/A
Previous Run	: 34737	Drawing Revision	: A1
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 05/12/2008
Checked & Approved By	: <u>JLD 08-11-26</u>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-07-19 JLM	Verified By:	EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 1.4574 sf(s)/Unit Total : 29.1480 sf(s)
 2024-T3 .032 sheet
 Batch: 109240 B8-12-8

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3259
 Dwg Rev: A1
 Prog Rev: A1

B8-12-8

2-Deburr if necessary B8-12-8

(24)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B8-12-8**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Sosketo center
24

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/11 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:51 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 43774

Part Number: D32595

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



24X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m- 08/12/12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST181

SS 08/12/12 (24)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43774
Description: Spacer		Part Number:	D3259-5
Inspection Dwg: D3259	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.994	X			
1.000	+/-0.005	1.000	✓			
5.000	+/-0.005	5.001	✓			
12.000	+/-0.005	12.003	X			
3.5000	+/-0.005	3.498	X			
0.875	+/-0.005	.874	X			
0.260	+/-0.010	.261	X			
R0.50	+/-0.030	.50				
0.250	+/-0.010	.251	X			
0.875	+/-0.005	.870	X			
Ø0.098	+0.005/-0.000	.102	X			
0.550	+/-0.010	.545	X			
R0.50	+/-0.030	.50	✓			
10.062	+/-0.010	10.062	✓			
R0.13	+/-0.030	.13	X			
0.032 thick	+/-0.010	.031	X			
0.130	+/-0.010	.132	✓			

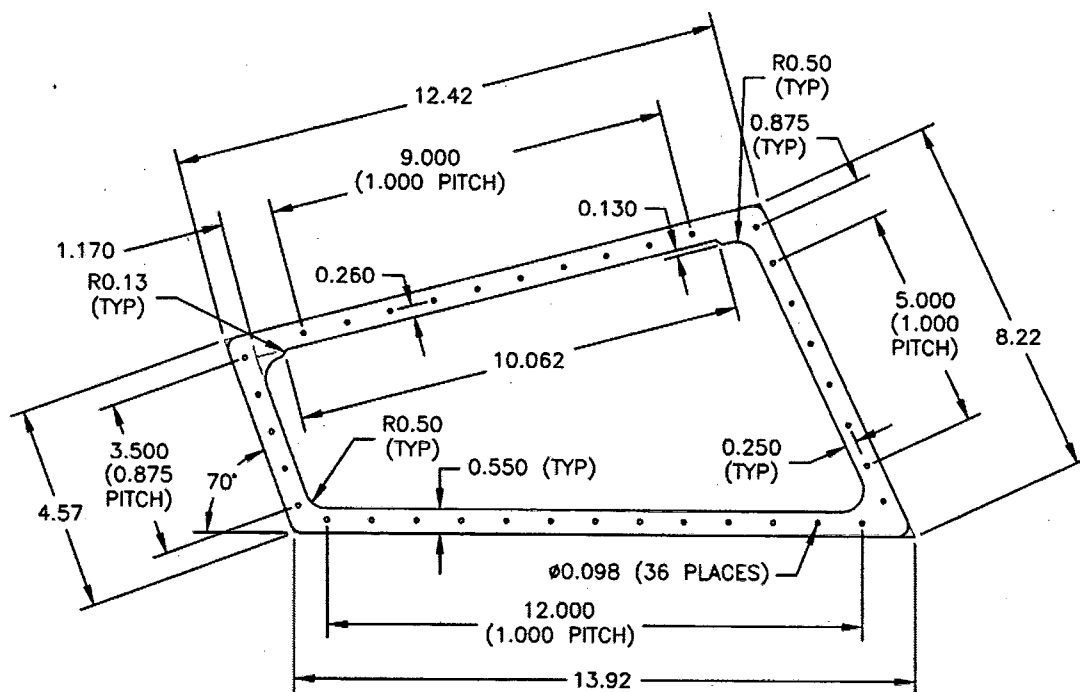
Measured by: LB	Audited by: S	Prototype Approval:	N/A
Date: 8-12-9	Date: 08/26/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue	KJ/JLM	



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3259	REV. A SHEET 5 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.02.25



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 UNCONTROLLED COPY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

RETURN TO
ENGINEERING

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 43774

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